

Date: Thursday, 04/12/2008 9:47:41 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABLE GUARD
Job Number : 43907	
Estimate Number : 12410	
P.O. Number :	Part Number : D34993
This Issue : 04/12/2008 S.O. No. :	Drawing Number : D3499 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 41875	Material :
Written By :	Due Date : 12/01/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JLD 0812.04</u>	
Comment : Est Rev:A New Issue 06-05-05 JLM	
Est Rev:B As per Rev B 06-08-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB625	UHMW .625 Black Tivar 1000
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Comment: Qty.: 1.1351 sf(s)/Unit Total: 4.5402 sf(s)

UHMW .625 Black Tivar 1000

Batch: 109313 HB 8-12-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3499

Dwg Rev: B HB 8-12-11

Prog Rev: B

2-Deburr if necessary HB 8-12-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment:

HAAS CNC VERTICAL MACHINING #1



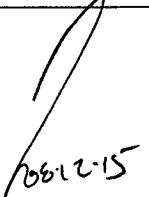
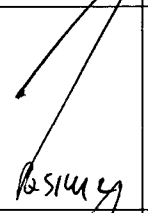
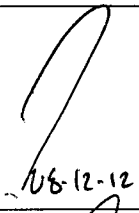
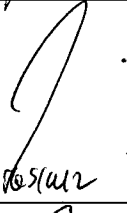
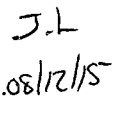
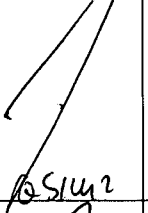
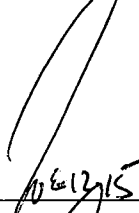

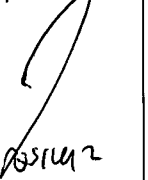
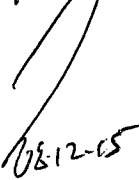
1- Mill as per Folio FA636 Rev: AA & Dwg D3499 Rev: B

2-Deburr per dwg D3499

JL 08/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3499-3 PAR #: N/A Fault Category: Prod/mat & Small NCR: Yes No DQA: D Date: 08/12/22
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/12/23

NCR: <u>43907</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/15	20	Due to the taper during hole cutting on the W.S. + the 0.210 tapers to 0.210 on the opposite side. R.C. Set off set & process.		- The 0.210 is on the edge of the hole, from sort of blowing out the pressure. - reduce set off set to down size the hole. - Hole size in within tolerance, inside to hole. - Acceptable.	 8-12-15	 08/12/15	 08/12/15	 08/12/15
08/12/15	40	- operator modified program for radius sequence, forgot to add half of cutter & causing it to machine a groove in		- Scrap part no replace, qty is already over the wro requirement. - operator adjusted the tool setting	 08/12/15		 08/12/15	 08/12/15
		- the part. R.C. operator error: material Raw/Rough material was purchased & Material not faced to a certain thickness.		- review the material requirements for next order.			 08/12/15	 08/12/15

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 43907

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/12/15

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
C'BORE AS PER DWG D3499

mf 08/12/16

(11)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/12/16

(11)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RP 08/12/18

(11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ALLEN 10 NEW SURF

PO 8/14/19 (11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22

Job Completion



mf 08-12-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

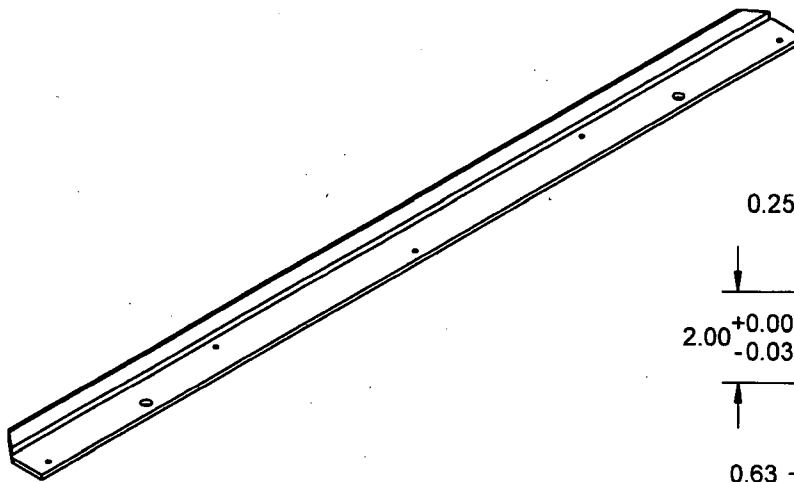
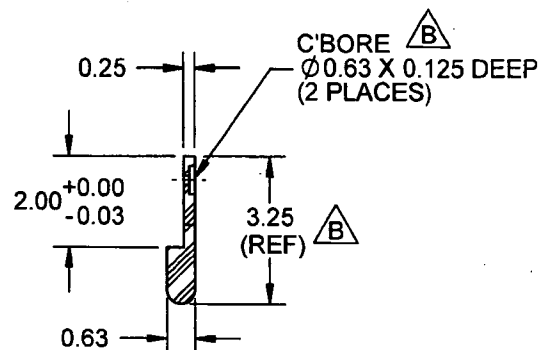
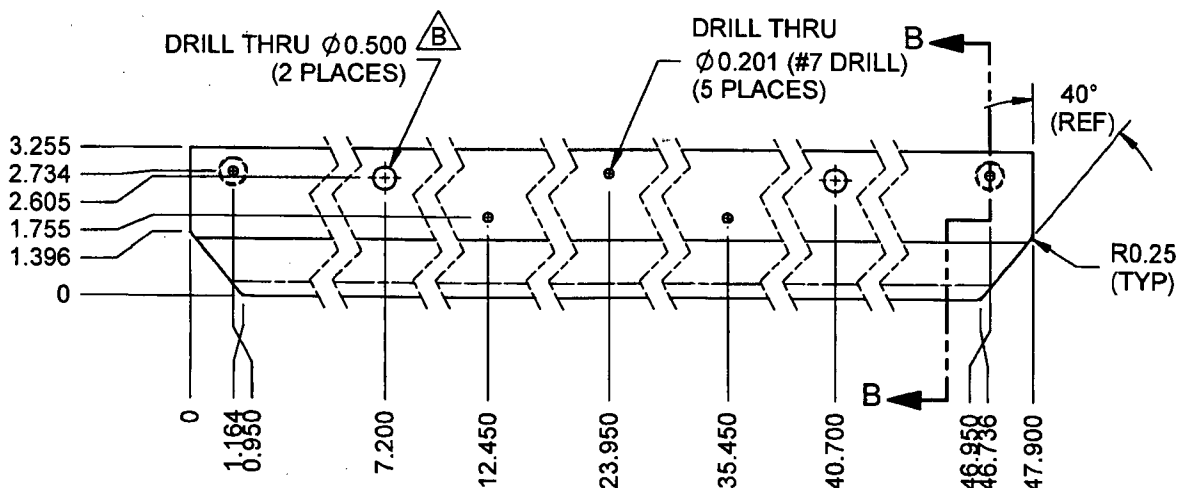
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3499	REV. B SHEET 3 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4

**RELEASED**
06-10-2015**SECTION B-B****D3499-3 CABLE GUARD****NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. *43907*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries